

Date: Thursday, 11/29/2007 11:07:07 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LATCH BRACKET		
Job Number	: 36043		Part Number	: D2583		
Estimate Number	: 10994		Drawing Number	: D2583 REV. B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/29/2007	S.O. No. : N/A	Drawing Revision	: B		
Prsht Rev.	: NO		Material	: N/A		
First Issue	: N/A		Due Date	: 12/6/2007		
Previous Run	: 33893		Qty:	100	Um:	Each
Written By	:		Comment			
Checked & Approved By	:		Est: 00.11.01	Removed P/O for Powder Coat- in house		
			processDM			
			Est: D 06.07.21	Waterjet	EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S040	5052-H32 040 Sheet 13.2516
		Comment: Qty.: 0.1227 sf(s)/Unit Total : 12.2745 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S040) Batch: 104921 1B 07-12-04
2.0	WATER JET	FLOW WATER JET 1B 07-12-4
		Comment: FLOW WATER JET 1-Cut as per Dwg D2583 Dwg Rev: B Prog Rev: B 108
		2-Deburr if necessary 1B 07-12-4
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 1B 07-12-4
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK 1B 07-12-4
		Comment: SECOND CHECK 1B 07-12-4
5.0	BRAKE NC	NC BRAKE 1B 07-12-4
		Comment: NC BRAKE Deburr → Form on CNC Brake as per Dwg D2583 1B 07-12-4

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 8/12/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:07:07 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 36043

Part Number: D2583

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC5

INSPECT WORK TO CURRENT STEP



11/12/19



Comment: INSPECT WORK TO CURRENT STEP

QSP019

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

11/07/20

X108

8.0 POWDER COATING

POWDER COATING



M 106379



108X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-L 07/12/20

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



108

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 07-12-20

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 222

11/12/20 50 108

11.0 QC21

FINAL INSPECTION/W/O RELEASE



108

Comment: FINAL INSPECTION/W/O RELEASE

11/12/20

Job Completion



2007/12/20

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	<u>36043</u>
Description: Latch Bracket	Part Number:	<u>D2583</u>
Inspection Dwg: D2583 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	07-12-4	Date:	2/12/06	Date:	N/A

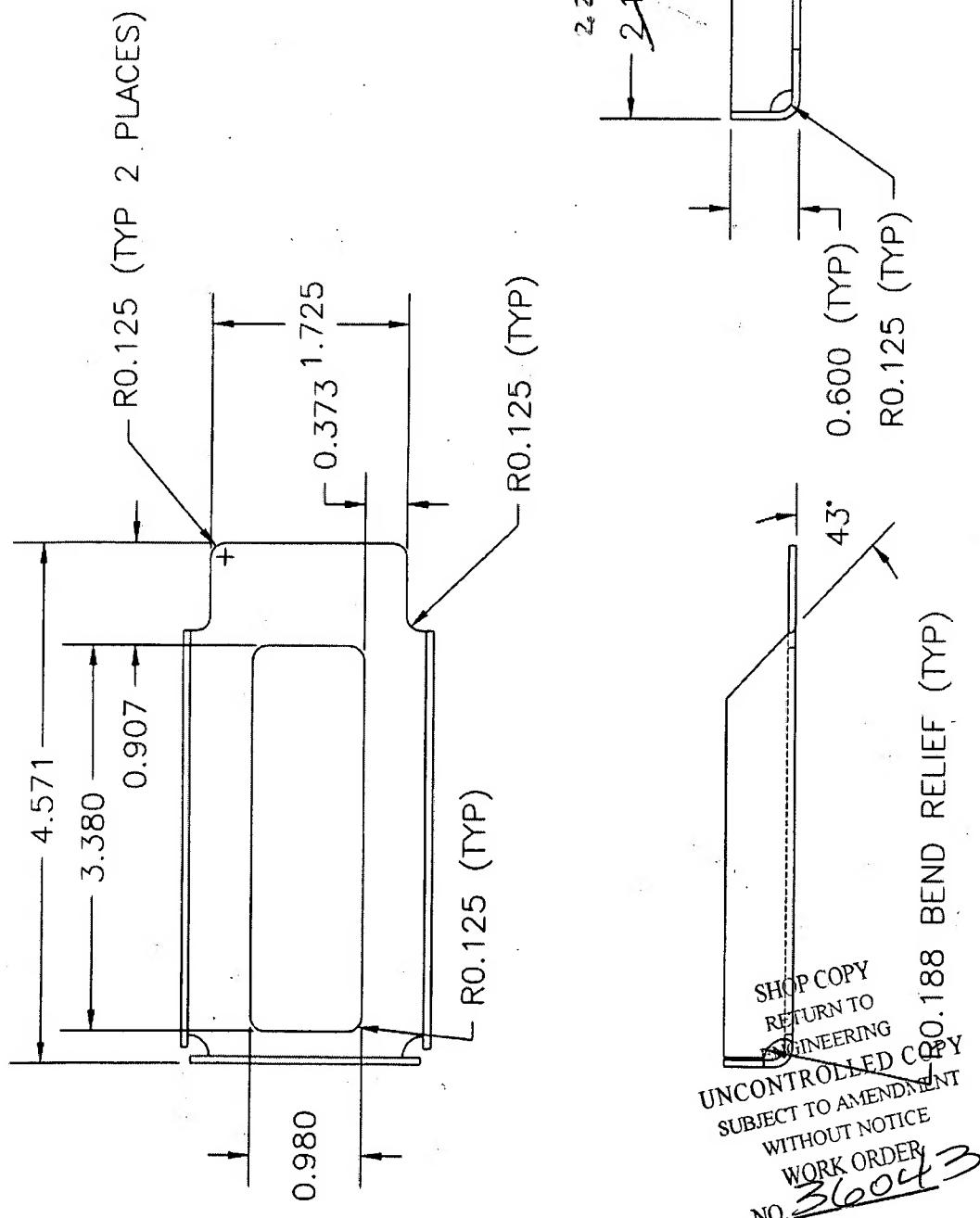
Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue	KJ/JLM	SM

DART

OF COPY IS
Dart

DESIGN MIKE M.	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED (P)	APPROVED KE	DRAWING NO. D2583
DATE 99.02.22		REV. B SHEET 1 OF 1
		TITLE LATCH BRACKET
A	96.07.10	SCALE 2:3
B	99.02.22	NEW ISSUE
		CHANGE OF FINISH (PER TSR A887)

RELEASED
KE 99.02.25



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

